Work Order ID 88810

88810

August-03-12 2:49:52 PM

Item ID:	D350-567-113	Accept	*N9000401OO*	Setup Start *NS1*
Revision ID:				
Item Name:	Replacement Window, Extra Large			Stop *NS2*
Start Date:	03/08/2012 Start Qty: 2.00	*2*	Cust Item ID:	
Required Date: 17/08/2012	Req'd Qty: 2.00	*2*	Customer:	
Reference:				

Approvals: Process Plan: _MLJ_   Date: _12/08/03_ Tooling: _____   Date: _____

Run Start *NR1*

QC: _____   Date: _____   SPC (Y/N): _____   Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-567	Rev D								

100 *100* DC Document Control	DOCUMENT CONTROL habel Blanc Memo Photocopy bluefile & type labels per PPPD350-567-113 CHG003	0.00 0.00	for MLJ 12-9-14 ②

110 *110* Packaging Packaging	Packaging Memo Pick Packing Kit ***ENSURE DT 8439 TEMPLATE IS INCLUDED***	0.00 0.00	12/9/13

120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order: _____	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**
Part No. _____	Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐
NCR No. _____		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

☐ Bending	☐ Bend	☐ Grain	☐ Ovalized ☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance ☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect ☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing ☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge ☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____

General (column header above Bend/Grain columns)

| Item ID: | D350-567-113 | | Accept | *N9000040100* | Setup | Start | *NS1* |

Revision ID:

Item Name: Replacement Window, Extra Large

Stop *NS2*

| Start Date: | 03/08/2012 | Start Qty: 2.00 | *2* | Cust Item ID: |
| Required Date: 17/08/2012 | Req'd Qty: 2.00 | *2* | Customer: |

Reference:

Run Start *NR1*

| Approvals: | Process Plan: _____ | Date:_____ | Tooling: _____ | Date:_____ |
| | QC: _____ | Date:_____ | SPC (Y/N): _____ | Date:_____ |

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130 Packaging	Packaging					2x			8⊘
Packaging	Memo	0.00							12-9-18
	Identify and pack for shipping as per PPPD350-567-113 Location:_____ PPP Rev: ___D___ 8826/								
140	QC21- Final Inspection - Work Order Release	0.00							
140 QC									12/9/19 ⊘⊘
Quality Control	Memo	0.00							mc 12-09-18

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐   Crosstube ☐   Water Jet ☐   Engineering ☐
Machining ☐   Small Fab ☐   Prod. Eng. Coor. ☐   Quality ☐
Thermoforming ☐   Finishing ☐   Rec/Store/Packaging ☐   Other ☐
Large Fab ☐   Composite ☐   Supplier ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped.	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	

Picklist Print

August-03-12 2:49:56 PM

Work Order ID: 88810

Parent Item: D350-567-113

Parent Item Name: Replacement Window, Extra Large

88810
D350-567-113

Start Date: 03/08/2012   **Required Date:** 17/08/2012

Start Qty: 2.00   **Required Qty:** 2.00

Comments: IPP Rev:A 04-08-24 New Issue JLM
IPP Rev:B 08-10-07 as per revD DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
212-12		Purchased	No			110	Each	297.0000	12	24			
212-12 Receptacles									**		M122800		

	Location		Loc Qty	Loc Code
	380		200	
		122452	200	
	ST380		97	
		120077	20	
		121827	77	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2600-6		Purchased	No			110	Each	387.0000	12	24			
2600-6 Camlock Stud									**		M122763 12/9/14		

	Location		Loc Qty	Loc Code
	ST380		387	
		120077	8	
		121556	4	
		122317	34	
		122335	145	
		122441	196	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order: _____	**DISPOSITION**		**AGAINST DEPARTMENT/PROCESS**			
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
NCR No. _____	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other
_____
_____
_____

Work Order ID: 88810

Parent Item: D350-567-113

Parent Item Name: Replacement Window, Extra Large

88810
D350-567-113

Start Date: 03/08/2012 **Required Date:** 17/08/2012
Start Qty: 2.00 **Required Qty:** 2.00

2600-LW	Purchased	No		110	Each	511.0000	12	24

2600-LW
Camloc Retaining Washer

**

Location		Loc Qty	Loc Code
380		196	
	122452	196	
ST380		312	
	121524	112	
	122317	200	24
ST381		1	
	121287	1	
ST398		2	
	120648	2	

AN526C832R9	Purchased	No		110	Each	382.0000	21	42

AN526C832R9
Screw

**

Location		Loc Qty	Loc Code
ST346		373	
	120181	21	
	121556	152	22
	122151	200	20
ST347		9	
	118983	9	

AN960JD8	NAS1149DN832J	Purchased	No		110	Each	0.0000	42	84

AN960JD8
Washer

**   MI22441 12/9/13

NCR: Yes / No   **WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: Date:

	DISPOSITION	AGAINST DEPARTMENT/PROCESS

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION
Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS
Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear
☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped.
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General
☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other
_____
_____
_____

August-03-12 2:49:56 PM

Work Order ID: 88810

88810

Parent Item: D350-567-113

D350-567-113

Parent Item Name: Replacement Window, Extra Large

Start Date: 03/08/2012   **Required Date:** 17/08/2012

Start Qty: 2.00   **Required Qty:** 2.00

| D2463 | Manufactured | No | | 110 | f | 474.9074 | 7.166 | 15.08632 | |

D2463

Seal

**   _____

Location	Loc Qty	Loc Code
ST404	474.90737	
72232	15.38	
79478	0.43737	
83542	459.09	

1x (D2463-0860 as per dwg) CUT TO 86.00"

| D3290-041 | Manufactured | No | | 110 | Each | 5.0000 | 1 | 2 |

D3290-041

Replacement Window Assembly

**   B85955

Location	Loc Qty	Loc Code
ST213	1	
82838	1	
ST218	3	
73721	2	
79360	1	
ST219	1	
79360	1	

| FG-778150-550-ROL | Purchased | No | | 110 | sf | 2,764.491 | 18 | 36 |

FG-778150-550-ROL

7781 9oz Glass 50"x125yd

**   12/9/13

Location	Loc Qty	Loc Code
CA	2764.491	
104845	3	
108932	18	
111166	392	
113905	564	
117602	664.651	
119099	1122.84	

36

2sq yards

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	**DISPOSITION**		**AGAINST DEPARTMENT/PROCESS**				

| Work Order: _____ |
| Part No. _____ |
| NCR No. _____ |

DISPOSITION

| Rework ☐ |
| Scrap ☐ |
| Use-as-is ☐ |
| Work Order Update ☐ |

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear		General				
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	

Work Order ID: 88810

Parent Item: D350-567-113

Parent Item Name: Replacement Window, Extra Large

88810
D350-567-113

Start Date: 03/08/2012   **Required Date:** 17/08/2012

Start Qty: 2.00   **Required Qty:** 2.00

MS20426AD3-5	Purchased	No		110	Each	12,044.00	24	48

MS20426AD3-5

Rivet

**

Location	Loc Qty	Loc Code
ST316	12044	
4179	390	
4444	5558	48
4533	6096	

MS21042L08	Purchased	No		110	Each	1,301.000	21	42

MS21042L08

Nut

**

12/9/13

Location	Loc Qty	Loc Code
315	500	
122452	500	42
ST300	1	
121524	1	
ST317	800	
122141	800	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ **Part No.** _____ **NCR No.** _____	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	